



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3763-041
Job Sheet 168552



Part No: D3763-041

Job Qty: 4 ea

Part Name: End Fitting Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 08-05-20 new issue DD verified by:ec IPP Rev:B 08-07-18 revB as per dwg DD
verified by:EC IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/23/17	0.00	0.00	Start Up Large Fab-1		<i>JPC</i>
100	Packaging	4 pcs		11/23/17	0.00	0.00	Packaging1		<i>JPC</i>
110	Large Fab	4 pcs		11/23/17	0.00	0.92	Large Fab 2		<i>JPC</i>
120	QC	4 pcs		11/23/17	0.00	0.00	QC9		<i>PD 17-11-25</i>
130	QC	4 pcs		11/23/17	0.00	0.00	QC5		<i>PD 17-11-25</i>
140	HandFinish	4 pcs		11/24/17	0.00	0.14	HandFinish1		<i>2017-11-27 JPC</i>
150	QC	4 pcs		11/24/17	0.00	0.00	QC3		<i>38</i>
160	Packaging	4 pcs		11/24/17	0.00	0.00	Packaging3	<i>ST 257</i>	<i>Self</i>
170	QC21-SA	4 Ea		11/24/17	0.00	0.00	QC21		<i>IT</i>

Part Op 110 - 1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble as per dwg D3763 using locating pin D19039
Descriptions: *****ensure locating pin is in 0.221" hole***** 3-weld as per dwg D3763 QSI004 Alum. rod

Batch: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3763-1	4	4	0	0
	D3763-3	4	4	0	0

Part Specifications

Specifications could not be found.

Plex 11/16/17 4:52 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Sk _____ Ma _____ Thermo _____ La _____ Q _____		 S010910 End Fitting Assembly			
Date : _____		Step #: _____		PART NO: D3763-041 Revision: Operation: Change No: Start up Operation Mfg Date: 11/17/17 Job No: 168552					
Description Work Order Deviation 									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminatic ☐ Countersink ☐ Cut Too Short ☐ Instructions Ir ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminatic ☐ Countersink ☐ Cut Too Short ☐ Instructions Ir ☐ Drill Holes ☐	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐								
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminatic ☐ Countersink ☐ Cut Too Short ☐ Instructions Ir ☐ Drill Holes ☐								
OTHER : _____				1042) Approval ☐ Completed By _____ I / Supervisor _____ I Verification _____ Coordinator _____ Approval _____ ed Wrong _____ Dimensions _____ der tolerance _____ rrect _____ /Missing _____ ed _____					